

Date: Monday, 28/04/2008 8:14:57 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE HALF
Job Number	: 38826		
Estimate Number	: 13157		
P.O. Number	:	Part Number	: D37491
This Issue	: 28/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3749 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 37202	Drawing Revision	: A
	Type : SMALL / MED FAB	Material	:
Written By	:	Due Date	: 10/05/2008
Checked & Approved By	: <u>JLD 08.4.28</u>	Qty:	20 Um: Each
Comment	: Est Rev:A 08-02-05 new issue DD verified by:EC Est Rev B 08-02-27 rev.A as per ecn 1139 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0196 sf(s)/Unit Total : 0.3927 sf(s)

304/316 .125 Sheet

(M304S0125)

Batch: 104934 IB 8-4-29

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3749

Dwg Rev: AProg Rev: A

2-Deburr if necessary

IB 8-4-29

32
08/04/30 32

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEIB 8-4-29

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08/04/30 +32

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Form as per Dwg D3749 using CNC Brake

08/05/01 32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:14:57 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE HALF

Job Number: 38826

Part Number: D37491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/01 *X32* *counter*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS7*

08-05-01 *X32*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/05

Job Completion



mf 08-05-02

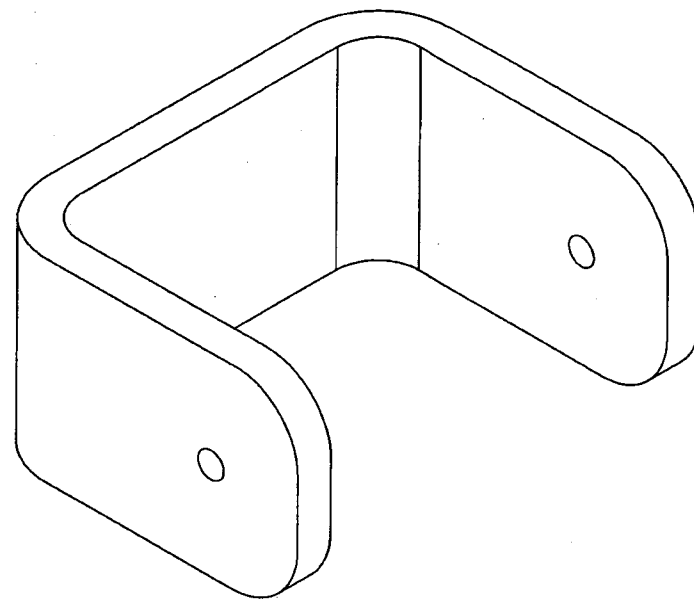
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries






D3749-1 HINGE HALF

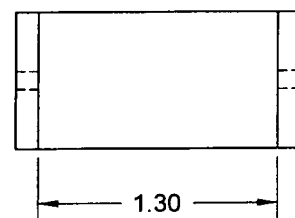
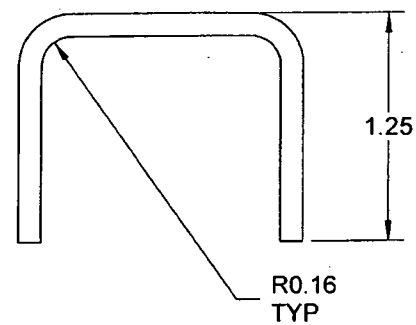
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

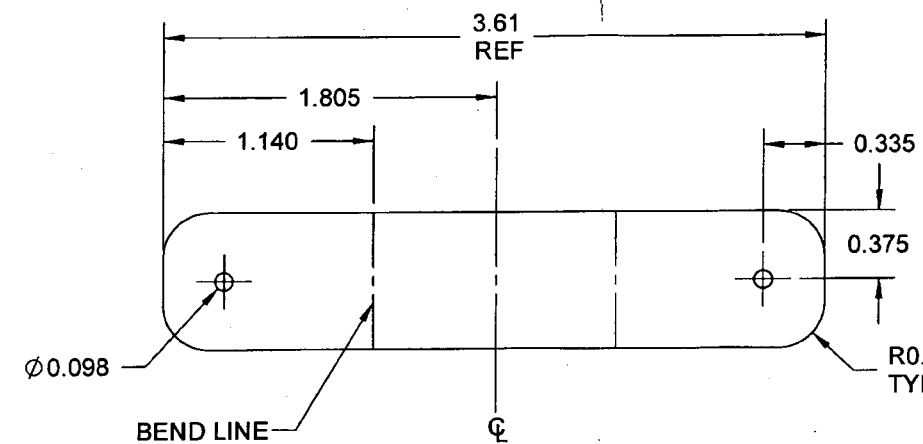
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16 08.02.25

A		NEW ISSUE		AJS		08.02.01			
REV.		DESCRIPTION				BY		DATE	
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
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MFG. APPR.				D3749				SHEET 1 OF 2	
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D3749-1 HINGE HALF



D3749-1F FLAT PATTERN

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NO. 38824

08.02.25

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